

Work Order ID 83065

April-12-12 4:06:43 PM

83065

Page 1

Item ID: D2804-1

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bracket

Start Date: 12/04/2012 Start Qty: 6.00 *6*

Cust Item ID:

Required Date: 26/04/2012 Req'd Qty: 6.00 *6*

Customer:

Reference:

Approvals: Process Plan: MLE Date: 12/04/13 Tooling:

Run Start *NR1*

QC: Date: SPC (Y/N):

Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2804

Rev C

100

100

FLOW WATER JET

0.00

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per File D2804-1-2_Blank

6061 BAR

Dwg Rev: C

.500 x 10.00

Prog Rev: C

2-Deburr if necessary

110

110

HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per folio FA103

120

120

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

6

0

Jm/d
12-5-12

PD/B

12/05/29

6

0

PD/B

12/05/29

6

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 83065

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Item ID: D2804-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Bracket

Stop

NS2

Start Date: 12/04/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 26/04/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									
145	QC3- Inspect Part Finish	0.00							
145									
QC	Memo	0.00							
Quality Control									

OK 12/04/01

6 76 1254

MB
6X 12/06/04

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Cust Item ID:

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Identify as per dwg & Stock Location: GA

0.00

150

Packaging

Memo

0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

6x

12/06/05

12/6/05

12-06-05

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DART AEROSPACE LTD		Work Order:	83065
Description: Bracket		Part Number:	D2804-1
Inspection Dwg: D2804	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.757	+0.005/-0.000	0.757	✓		PHO-01	VERN
Ø0.191	+0.005/-0.001	0.191	✓		Pingauge	
1.420	+/-0.001	1.420	✓		PHO-01	VERN
Ø0.507	+0.000/-0.001	0.5065	✓		PHD-01	VERN
0.250 deep	+/-0.010	0.250	✓		"	"
Ø0.507	+0.000/-0.001	0.5065	✓		"	"
Ø0.191	+0.005/-0.000	0.191	✓		Pingauge	
6.933	+/-0.010	6.933	✓		Hass	
7.578	+/-0.010	7.579	✓		Hass	
12.304	+/-0.010	12.304	✓		"	
0.125	+/-0.010	0.129	✓		PHD-01	VERN
0.500	+/-0.010	0.504	✓		"	"
0.125	+/-0.010	0.125	✓		"	"
0.250	+/-0.010	0.250	✓		"	"
0.875	+0.000/-0.001	0.875	✓		"	"
0.250	+0.000/-0.005	0.248	✓		PHD-09	

Measured by: <u>PB/BA</u>	Audited by: <u>amf</u>	Prototype Approval:	N/A
Date: <u>12/05/29</u>	Date: <u>12/05/31</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.25	New Issue	KJ/JLM	
B	06.06.05	Removed dimensions 12.625, 0.608, 0.437, 2.654	KJ/EC	
C	06.11.10	Revised per drawing revision C	KJ/JLM	
D	09.03.10	Tolerance revised for Ø0.757	KJ/DD	

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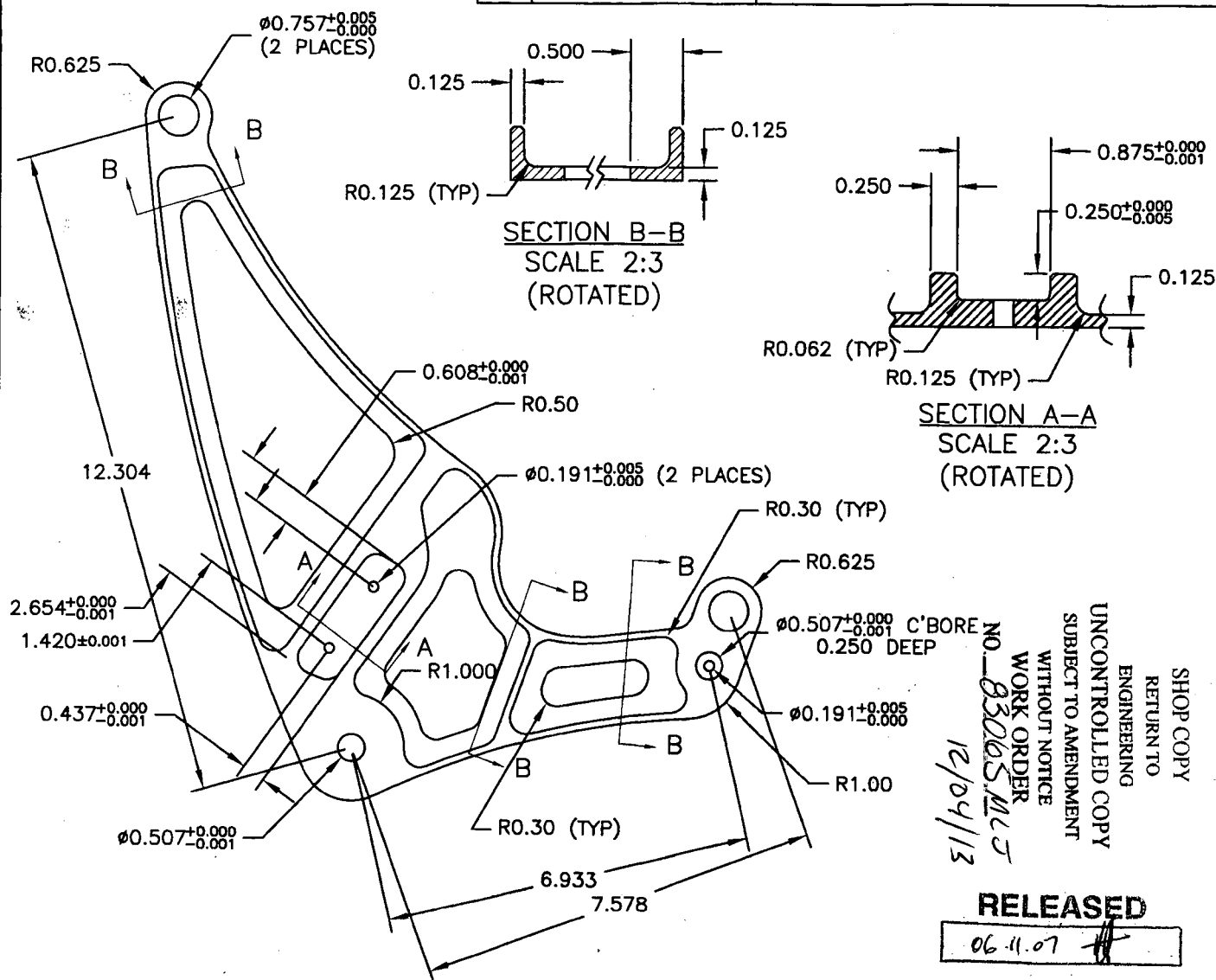
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2804	REV. C SHEET 1 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE	
B	04.11.22	ADD CUTOUTS & -043/-044	
C	06.10.16	CHANGE GEOM. TO ADD CLEARANCE	

**D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)**

- 1) MACHINE PER DRAWING FILE "D2804-1C.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE $R0.030 - 0.063$ ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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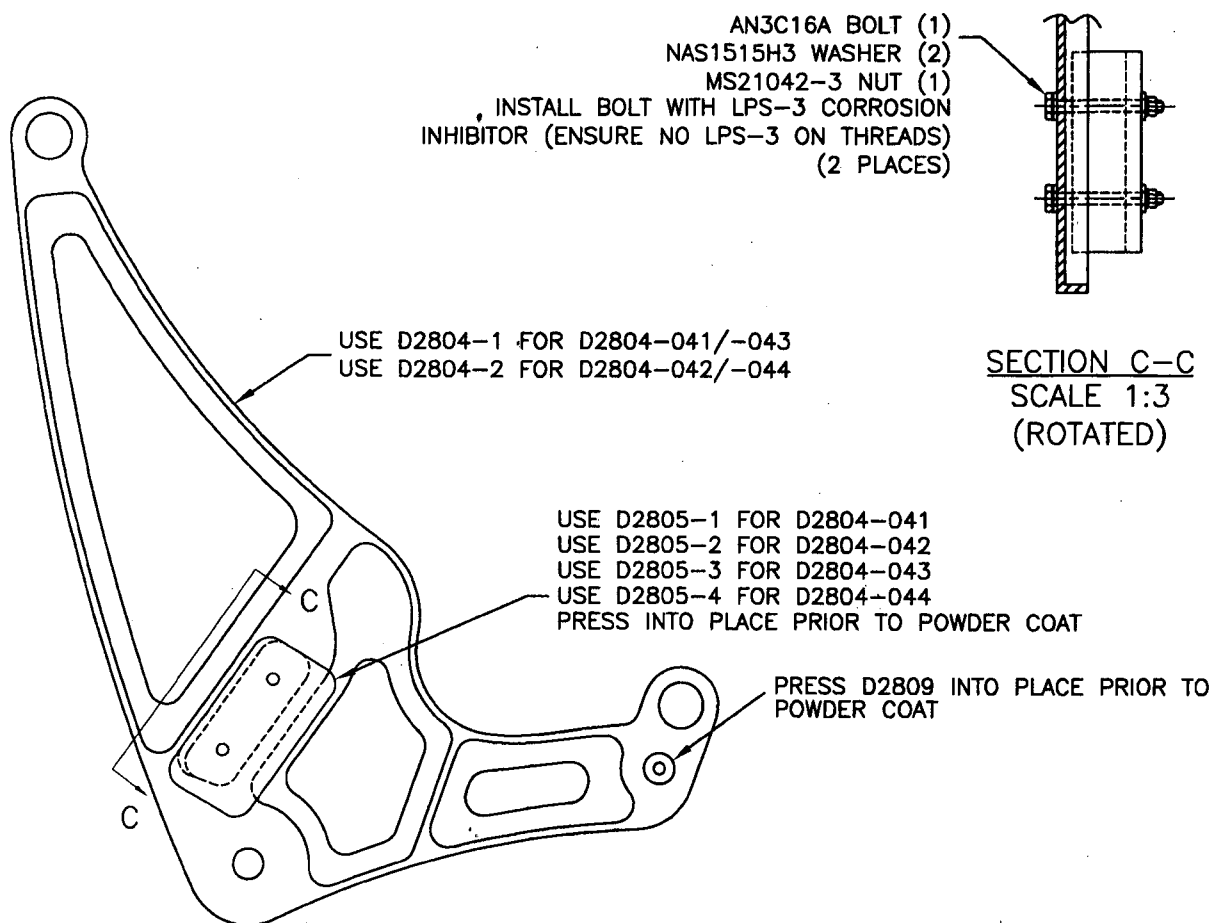
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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2804	REV. C SHEET 2 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3



83065

RELEASED

06.11.07

D2804-041/-043 BRACKET ASS'Y (SHOWN).

D2804-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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